

Date: Monday, 4/23/2007 1:52:37 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31993	
Estimate Number : 12728	
P.O. Number : <i>N/A</i>	Part Number : D353541
This Issue : 4/23/2007	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>MA</i>	Drawing Revision : <i>X B PH 07.04.26</i>
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/30/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 20 Um: Each
Comment : Est Rev New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: *M101373*

SAD 07/04/30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: *B*
 Prog Rev: *B*

SAD 07/04/30 (26)
SAD 07/05/01 26

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/30 (26)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/30 (26)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary *→ SAD 07/05/01 26*
 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 Identify as D3535-41
 Form Joggle on brake using Jig DT8158 as per Dwg D3535

SP 07/04/30 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31993

Part Number: D353541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/02 26

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

HL

07-05-03

26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h

07/05/04

26x

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 15

m-h

07/05/04

26x

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

26

Job Completion



U 07/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

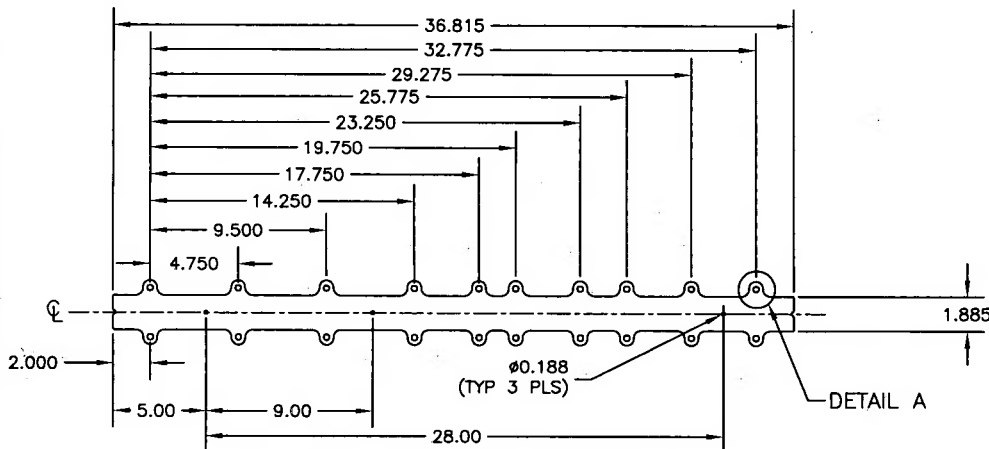
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

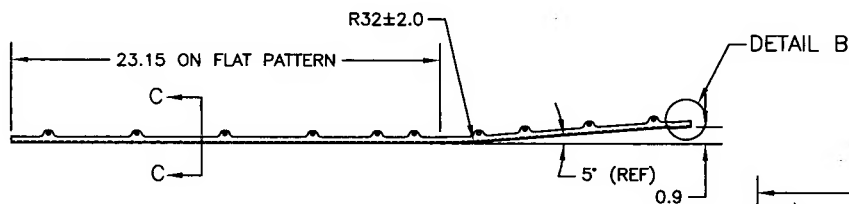
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

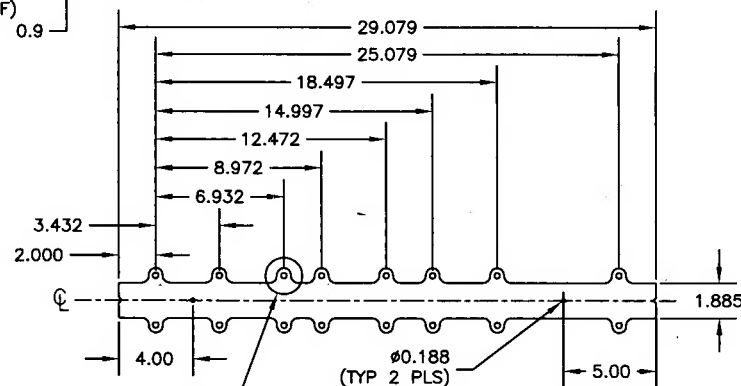
PRELIMINARY ISSUE



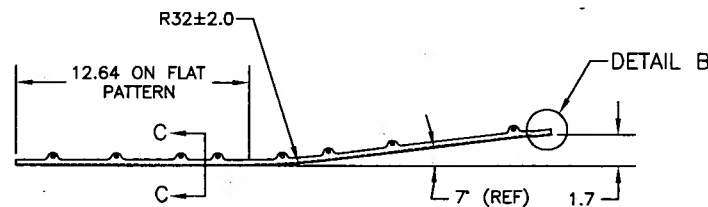
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NO. 31493
WORK ORDER
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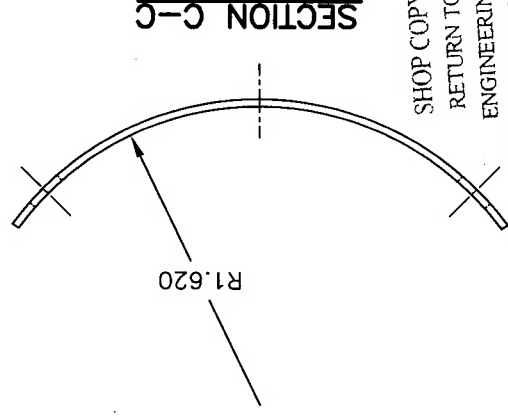
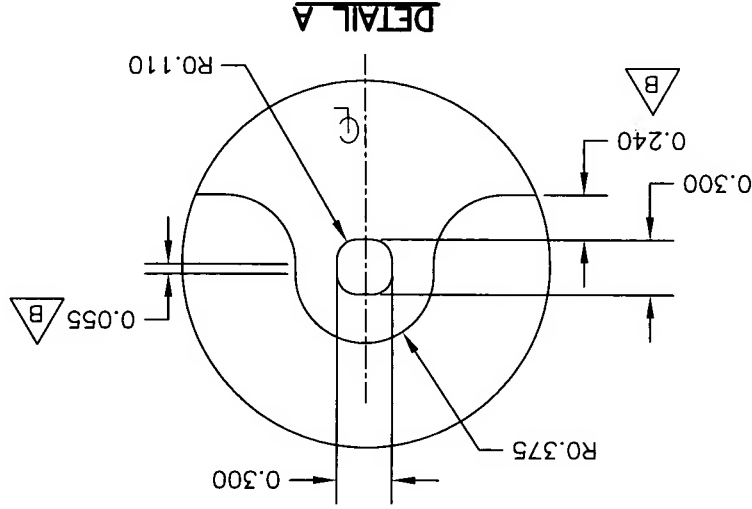
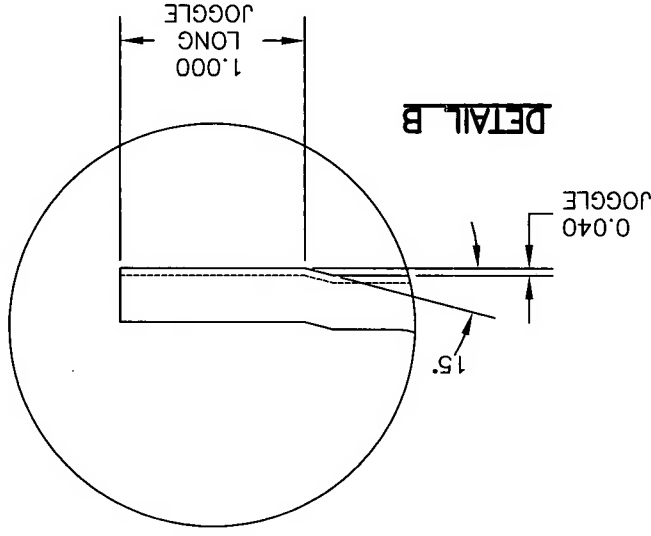
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 6 OF 7	SCALE 1:10

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

PRELIMINARY ISSUE



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WORK ORDER
NO. **31943**

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DART AEROSPACE LTD		Work Order: 31993
Description: <u>Wear Plate</u>		Part Number: D353541
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.00	± 0.030	4.011	✓		Vern ^{vertical}	
B $\varnothing 0.188$	$+0.005$ -0.001	0.190	✓		Vern ^{vertical}	
C 5.00	± 0.030	5.006	✓		Vern	
D 1.885	± 0.010	1.887	✓		Vern	
E 29.079	± 0.010	29.079	✓		M-T	
F 25.079	± 0.010	25.079	✓		Vern M-T	
G 18.497	± 0.010	18.500	✓		M-T	
H 14.997	± 0.010	15.000	✓		M-T	
I 12.472	± 0.010	12.475	✓		M-T / Vern	
J 8.972	± 0.010	8.971	✓		Vern	
K 6.932	± 0.010	6.934	✓		Vern	
L 3.432	± 0.010	3.433	✓		Vern	
M 2.000	± 0.010	2.006	✓		vertical Vern	
N 0.300	± 0.010	0.299	✓		Vern	
O 0.300	± 0.010	0.300	✓		Vern	
P 0.038	± 0.010	0.038	✓		Vern	
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: 	Prototype Approval:	N/A
Date: 07/04/30	Date: 07/04/30	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved

